

Date: Wednesday, 3/12/2008 1:41:59 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 37857	
Estimate Number : 10008	
P.O. Number :	Part Number : D2591
This Issue : 3/12/2008 S.O. No. :	Drawing Number : D2591 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 35659	Material :
Written By :	Due Date : 3/24/2008 Qty: 100 U
Checked & Approved By : <u>08 03 12</u>	Um: Each
Comment : Est Rev: Removed from 9 Digit 05-10-25 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
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Comment: Qty.: 0.2340 f(s)/Unit Total : 7.0200 f(s)  
ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500)  
Batch: H107513

2F 08/03/26

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
Cut blanks: 2.700" long

2F 08/03/26

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
1- Machine as per Folio FA 039 and Dwg D2591  
2-Deburr if required

2/4/8 08/04/14

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Receive + Inspect

INSURE C/SC ATTACHED 08/04/14 97

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/04/14 (457)

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: W/A

SP 08-04-16 (971)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 37857

Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

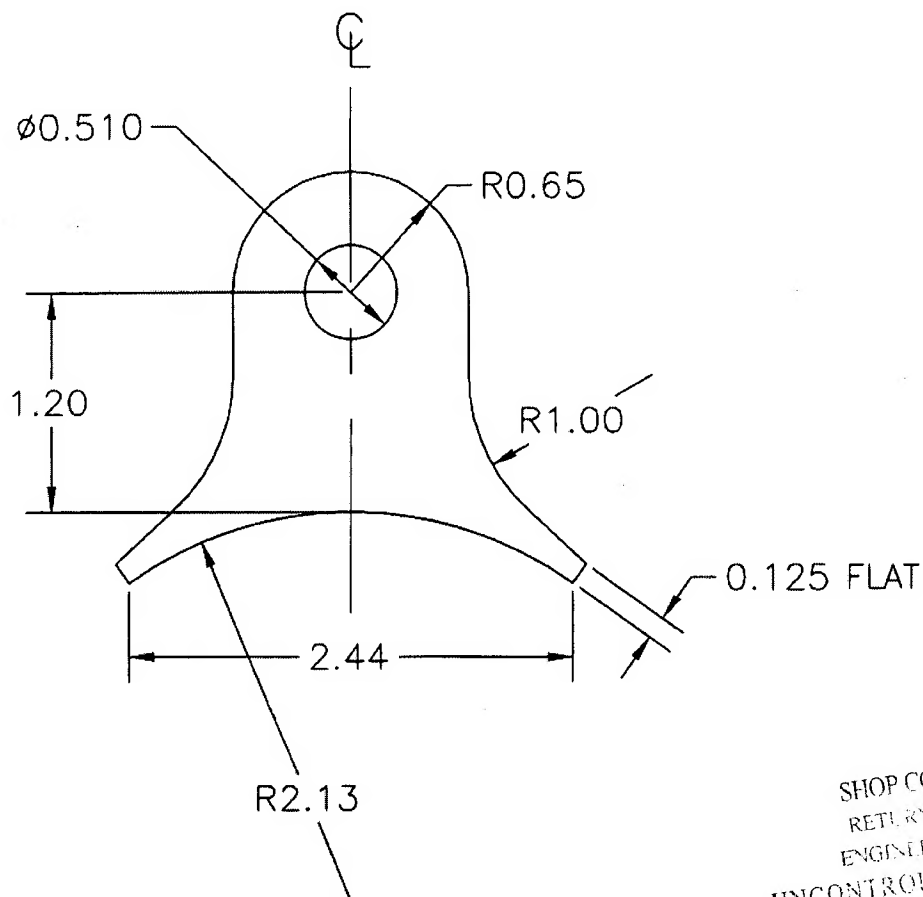
NOTE: Date & initial all entries





DESIGN <i>MEY</i>	DRAWN BY <i>MEY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	97.06.17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED  
98.01.21 DS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37857

0.063 # 00.04.05  
BREAK ALL SHARP CORNERS 0.010 TO 0.020  
MATERIAL: ASTM A36 STEEL 0.50 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
PART IS SYMMETRIC ABOUT CENTER-LINE  
ALL DIMENSIONS ARE IN INCHES



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

97

D2591

Lugs

5998

MATERIAL: supplied by DART M1010B0750X02500 M107513 B37857

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

A handwritten signature in black ink, appearing to read "Denise Robinson", with a long horizontal line extending to the right.

Denise Robinson

Vankleek Hill, April 14, 2008